

Work Order ID 60688

July 19, 2010 12:38:23 PM



PRELIMINARY ISSUE

Page 1

Item ID: D4101-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Pre-flight Step Ass'y

Start Date: 20/07/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 21/07/2010 Req'd Qty: 1.00

Customer:

Reference:

10-07-19



Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4101

PA4

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

SA 10/07/20

①

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*- Inspected to PA4
Dry only
8/20/2010*

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

*Prep.
Staff*

Jul 10-07-21

②

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Item ID:	D4101-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Pre-flight Step Ass'y					
Start Date:	20/07/2010	Start Qty:	1.00			
Required Date:	21/07/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10.07.22
 Res. A
 will be
 DEVIATION
 ON D4101-3
 10.07.30

POSITIVE RECALL

EFFECTIVE D.P.A. AUTH u
 RELEASED _____ DATE _____

MF
 10-7-21

Picklist Print

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Work Order ID: 60688

Parent Item: D4101-041

Parent Item Name: Pre-flight Step Ass'y







Start Date: 20/07/2010

Required Date: 21/07/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.07.07 new issue DD ver:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4  NUT		Purchased	No			100	Each	53.0000	1	1			
<div> <div>Location</div> <div>ST324</div> <div>114716</div> <div>115107</div> </div> <div> <div>Loc Qty</div> <div>53</div> <div>3</div> <div>50</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
AN4-22  Bolt		Purchased	No			100	Each	10.0000	1	1			
<div> <div>Location</div> <div>ST359</div> <div>115156</div> </div> <div> <div>Loc Qty</div> <div>10</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4101-1  Bracket		Manufactured	No			100	Each	0.0000	1	1			
D4101-3  Step		Manufactured	No			100	Each	0.0000	1	1			
D4101-5  Spring		Manufactured	No			100	Each	0.0000	1	1			
MS24665-136  Cotter Pins		Purchased	No			100	Each	157.0000	1	1			
<div> <div>Location</div> <div>ST309</div> <div>2421</div> </div> <div> <div>Loc Qty</div> <div>157</div> <div>157</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

SP 20/07/20

SP 10/07/20

SP 10/07/20

SP 10/07/20

SP 10/07/20

Picklist Print

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Work Order ID: 60688



Parent Item: D4101-041



Parent Item Name: Pre-flight Step Ass'y

Start Date: 20/07/2010

Required Date: 21/07/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

Purchased

No

100

Each

513.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST298

513

110153

2

114103

50

114884

200

115107

200

13910

61

2

SP 10/07/20

NAS1149D0463J

Purchased

No

100

Each

3,431.000

2

2



Washer

Location

Loc Qty

Loc Code

ST297

3335

115000

3335

ST298

96

10096

10

114576

68

114883

18

2

SP 10/07/20

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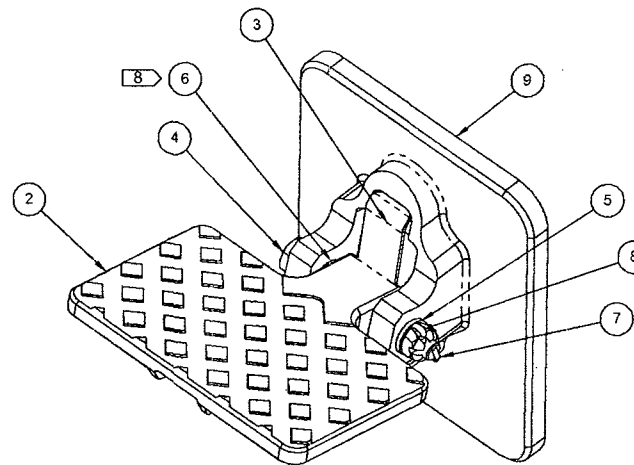
Shop Packet Print

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w/o ~~D410~~
60688



ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4101-041	PRE-FLIGHT STEP ASSEMBLY
2	1	D4101-3	STEP
3	1	D4101-5	SPRING
4	1	AN4-22	BOLT
5	2	NAS1149D0463J	WASHER
6	2	NAS1149D0416J	WASHER
7	1	MS24665-136	COTTER PIN
8	1	AN310-4	NUT
9	1	D4101-1	BRACKET



D4101-041 PRE-FLIGHT STEP ASSEMBLY

PRELIMINARY ISSUE

10.07.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4101-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.19 lbs
- 8) INSTALL NAS1149D0416J WASHER IN BETWEEN STEP AND BRACKET MATING FACES

PA4	AN310-4 WAS AN310 (ZN D3-1); REVISE NOTE MATERIAL (ZN A8-5); 0.850 WAS 0.870 & R0.13 WAS R0.06 (ZN CS-3 & B4-3)	RF	10.07.07
PA3	RE-DESIGN D4101-1 (ZN A4-2); R0.16 WAS R0.08 (ZN B3-5)	RF	10.06.02
PA2	REVISE PART LIST (ZN D3-1); REMOVE PRIME PAINT (ZN A8-2, A8-4); ADD MATERIAL SPEC TO D4101-5 (ZN A8-5)	RF	10.05.17
PA1	NEW ISSUE	RF	10.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4101	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		PRE-FLIGHT STEP ASSEMBLY	NTS
DATE	10.07.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	